Work Orde Wednesday, Nove				*126				Page 1			
Revision ID:	D3651-1 Gasket			*N900040100 ³							S1* S2*
Start Date: 11/12/2014 Start Qty: Required Date: 11/12/2014 Req'd Qty: Reference:		Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item Customer					()/	
Approvals:		•	Date: 14-11-12 Date:		I		I	Run Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr							·		
D3651	Rev	' B									
*100 *100* Waterjet FLOW CNC Waterje	t	FLOW WATER JET Memo 1-Cut as p if necessar	oer Dwg D3651Dwg Rev: / ry	0.00 0.00 B Prog Rev: B	_ 2-Deburr			6		De 14	1/11/12
*110 *11 0 * QC		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				6	DAS - 50	be/4	1/11/12
Quality Control	QC8- Inspect parts - seco		cond check	0.00				·	2-03		у ДАЗ 38 9 -8 9
120 QC		Memo		0.00				6			NOV 1 3 2014

Quality Control

DQA:	A: Date:					WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NON	I-C	UNFU	KIVIANCE / UI		ork Order up	odate only	AEROSPA	CE		
Work Ord	er:					DISPOSITION				AGAINST DE			·			
Part I					_	Rework Skid-tube Crosstube Machining Small Fab Use-as-is Thermoforming Finishing Composite				-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root					Desc	ription of work order update Initial Action				ion	Sign &			-		
Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	QC Inspecto	r		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	sign c/Data sip/Tooling ndling/Pre terial erator set/Setup cess uplier ining nsport						,									
	-						FA	ULT CAT	regory							
Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/Un ions Incomplete/U ned/off center eled I	·	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/S	tolerance ct ssing /rong	Pressure/Forced Set-up Temperature/Cui Weld Wrong Stock Pull					
	├				Fit/Function		i	Sequence								

Wednesday, November 12, 2014 10:23:10 A

Item ID: Revision ID: Item Name:	D3651-1 Gasket			Accept	*N900)*	Setup	Start Stop	171.	S1* S2*		
Start Date: Required Date: Reference:	11/12/2014	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item Customer:						10.	
Approvals:		in:		Tooling: SPC (Y/N):		Date: Date:	<u> </u>		Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 130 *130* Packaging	D	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code DAS 96	Accep Qty	Qty		Reject Number	Insp. Stamp
Packaging 140 *140 CC		QC21- Final Inspection Memo	- Work Order Release	0.00						10	ן אוורא	1948
Quality Control	s										Ü	MF 14-11,

DQA: Date:														
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QA CIOSEU.		Date								vork Order up	date only			
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS			
Part N					Rework Scrap		Skid-tube Crosstub Machining Small Fa			-	Water Jet d. Eng. Coor.		Engineering Quality	
NCR N	No				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier		Other	
Root				Desci	ription of work order update		Initial	Ac	tion	Sign &				
Cause	Date	e Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	1	QC Inspector	
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Landir	ng Gear			È	General] /n		Γ	7	. г		· / · · · · ·	
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}		Kink/Ripple	e/wave	-	Burrs		1	on Incomplete/U	· —	Part Lost/Mis	ssing	_	Veld	
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}		(Chatter	Tube	-	Drill Holes	-	Off-set	1						
}			ı	-	Finish	<u> </u>	4	Calibration		*********				
Turning Sequence Wave/Twist in Tube			Fit/Function	\vdash	ł	Sequence								
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Picklist Print

Wednesday, November 12, 2014 10:23:22 AM

Work Order ID: 126523

126523

Parent Item:

D3651-1

D3651-1

Parent Item Name:

Gasket

Start Date: 11/12/2014

Required Date: 11/12/2014

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 07-09-27

IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC 08-04-02

DD verified by: EC

IPP Rev:C ecn1162

DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		imary ocation	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
G89		Purchased	No			100	sf	9.5000	0.4652	2			
G89									**			De 14	11/12
Coated Cloth													<i> </i>

Location	Loc Qty	Loc Code	
MAT052	9.5		
123993	4.5		
124498	5		
94719			5. 3958

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DQA:	A: Date:												*	TO A C	7
•						WORK ORDER NON	-C(ONFO	RMANCE / U	IPDATE					
QA Closed:			Date:								ork Order up	odate only		AEROSPACE	
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	\vdash	Crimp/Kin	k/Ripple	/Wave	-	Burrs		1	on Incomplete/U	ngualified	Part Lost/Mi	 	- We	•	
		Cuffs	,, p,			Contamination	<u> </u>	1	ions Incomplete/		Part Moved	-		rong Stock Pulled	
	_	Crushing				Countersink		4	ned/off center		Positioned V	∟ Vrong			
		Heat Treat	t			Cut Too Short	$\overline{}$	Mislabe			Power Loss/		Oti	her .	
	-	nspection		Tube		Drawing	\vdash	Misread		L		· L			_
	—	Marks/Ch				Drill Holes		Off-set							_
	-					Finish		1	Calibration						_
		Fit/Function		4	equence						_				

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DART AEROSPACE LTD	Work Order:	26523
Description: Gasket	Part Number:	D3651-1
Inspection Dwg: D3651 Rev: B		Page 1 of 1

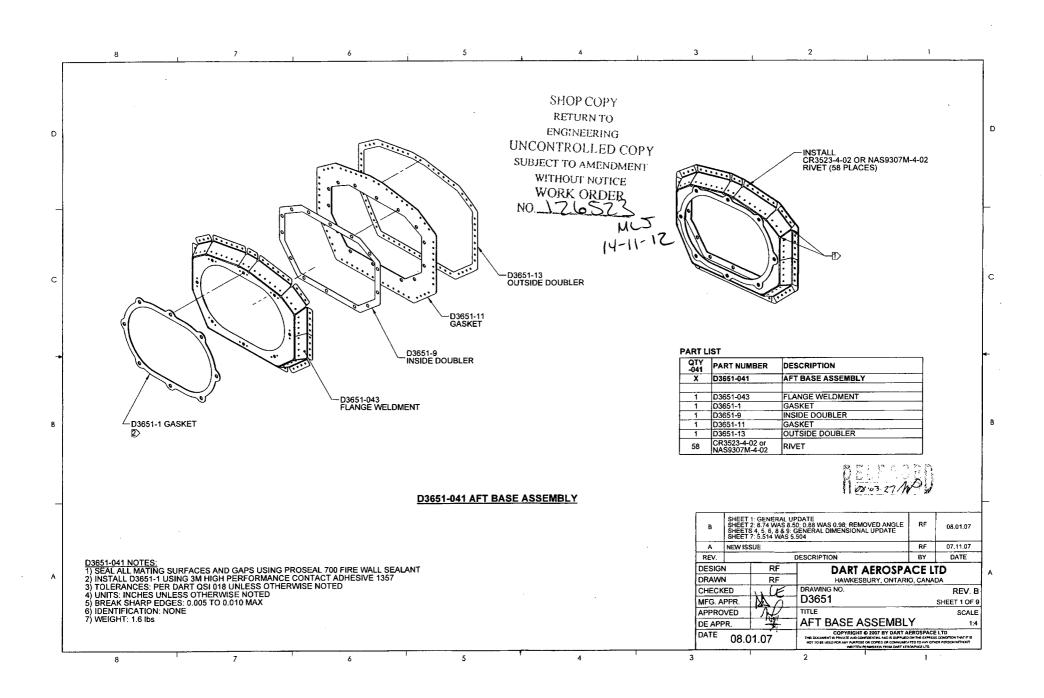
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

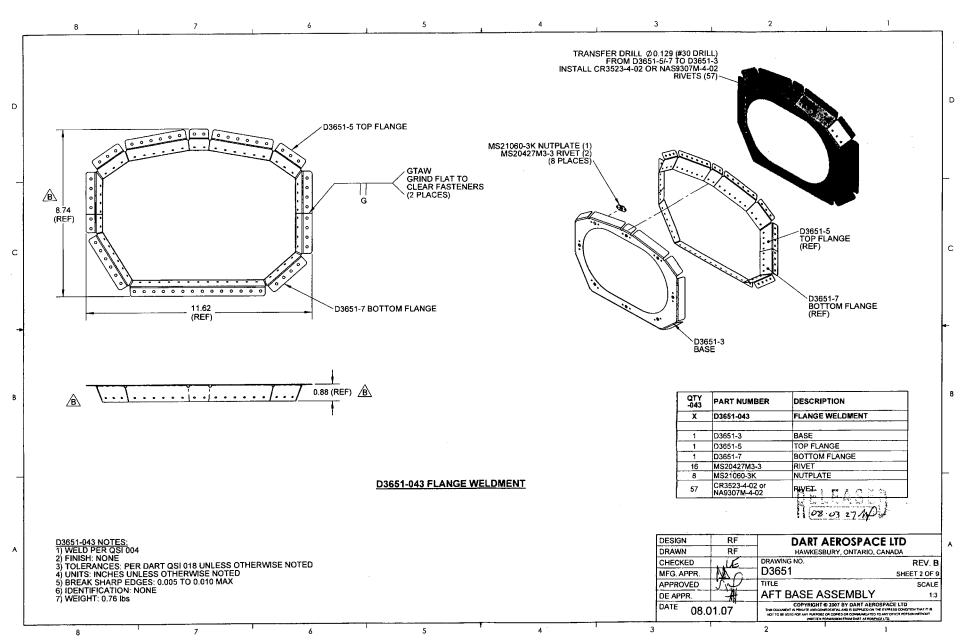
					,	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	.260	~		V: DC-62	
0.40	+/-0.030	.40	_		Tap	
6.69	+/-0.030	6.69	/			
5.25	+/-0.030	5.25	/			
9.59	+/-0.030	9.57	<u> </u>			
8.13	+/-0.030	8.13	~			
4.48	+/-0.030	4.46	/			
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3.03	+/-0.030	3.03				
2.60	+/-0.030	2.60	~			
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Measured by:	D	EAS	Audited by:	9-89	Prototype Approval:	N/A
Date:	14/11	#89	Date:	NOV 1 3 2014	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.04.17	New Issue	KJ/DD X	1
				- Parlian

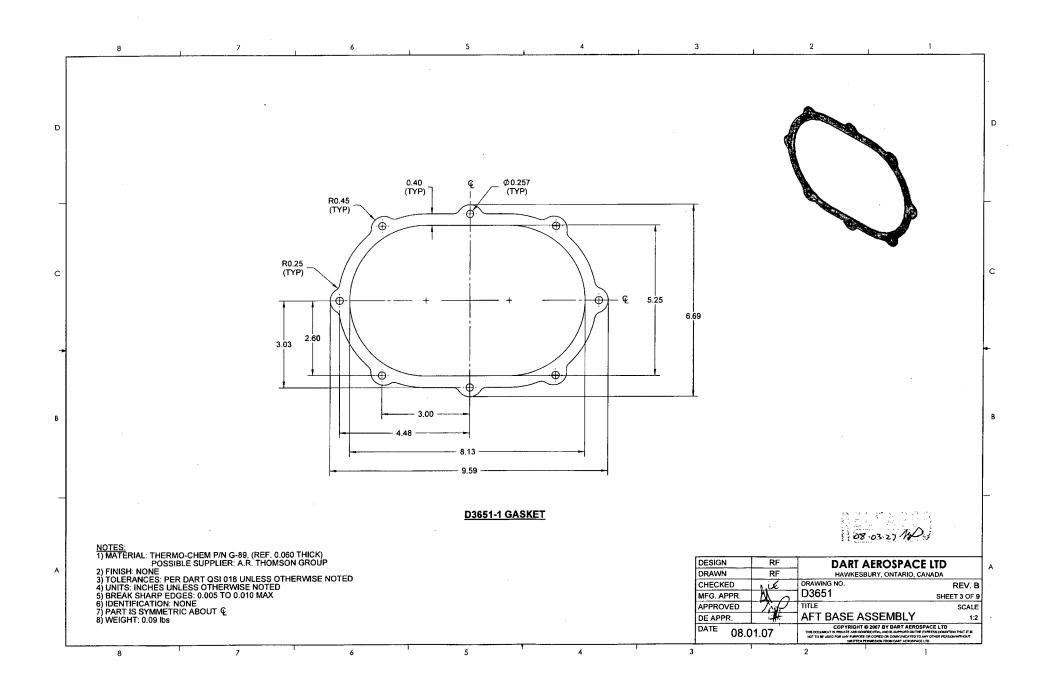


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	Cracks				Broken/Damage/Defect		Hardwa	re	[Part Incorrec	t	Temperature/	'Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/U	nqualified		Part Lost/Mis	ssing	Weld	
	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear		Part Moved		Wrong Stock (Pulled
ļ	Crushing				Countersink		_	ned/off center			Positioned W			
	Heat Tre				Cut Too Short		Mislabe		Į		Power Loss/S	Surge	Other	
	· ·	n Strip in	Tube		Drawing	\vdash	Misread	ŀ			· · · · · · · · · · · · · · · · · · ·			
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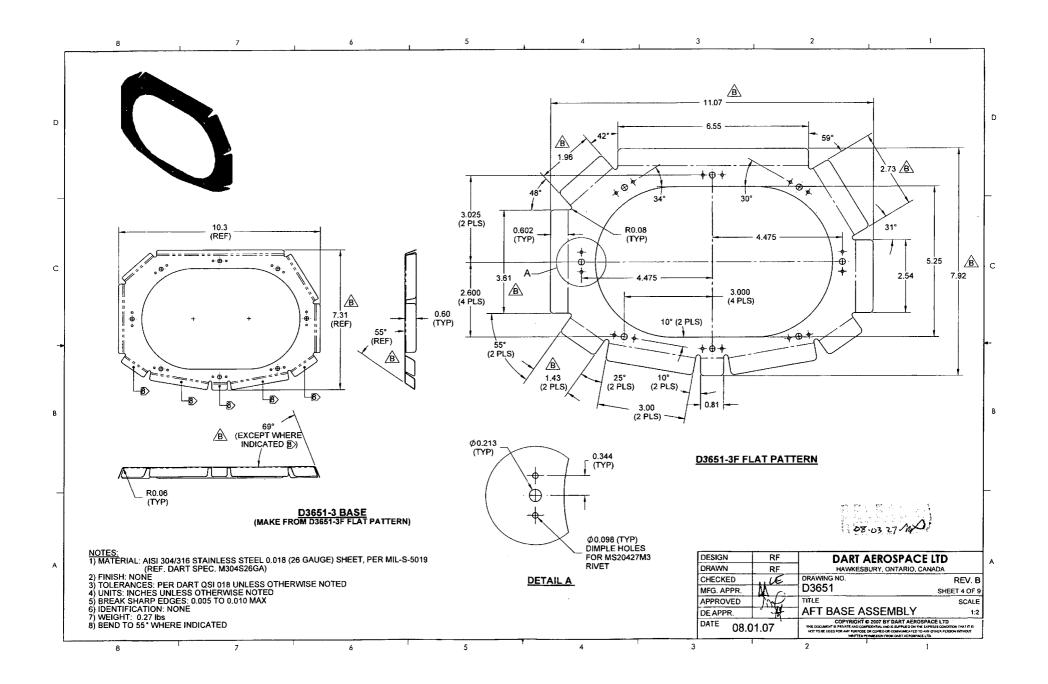


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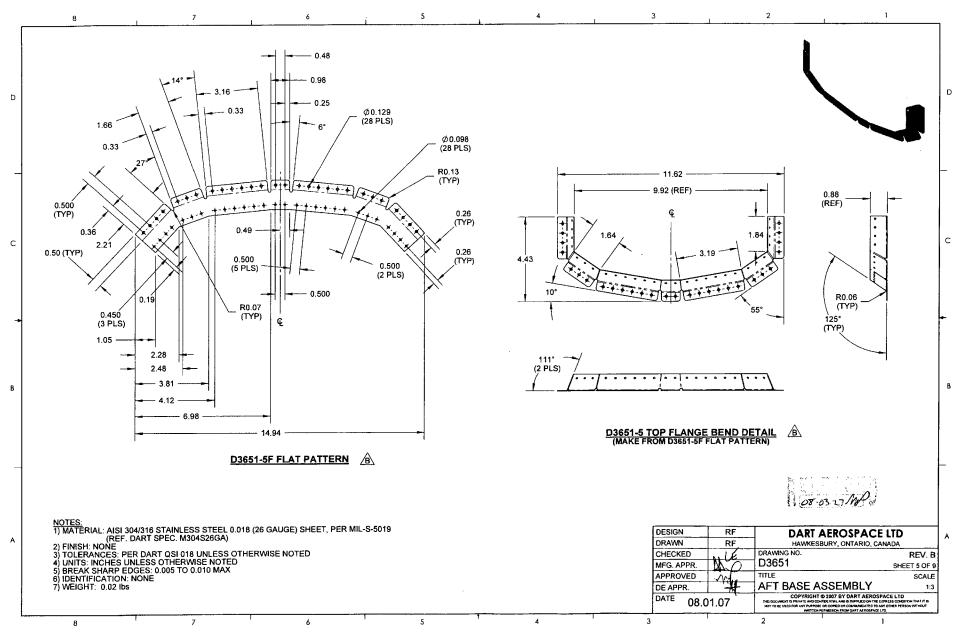
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DQA:			. Date:													
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	-					Rework]	Skid-tube Crosstube			Water Jet	Engineering				
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	יַ	urning Se	equence			Finish		Out of C	Calibration							
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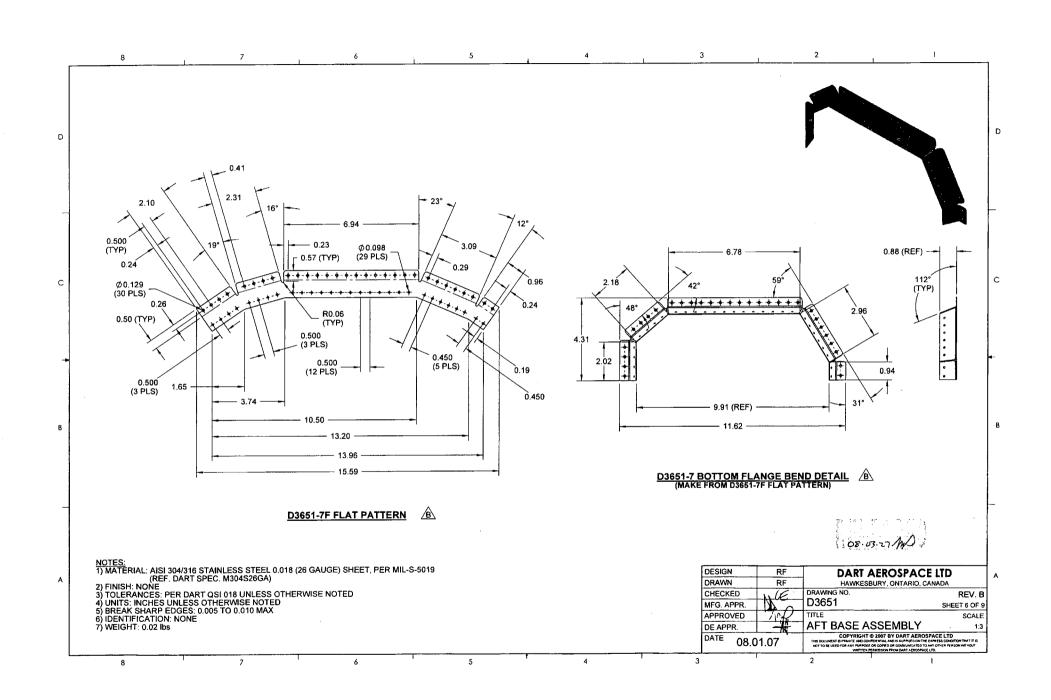


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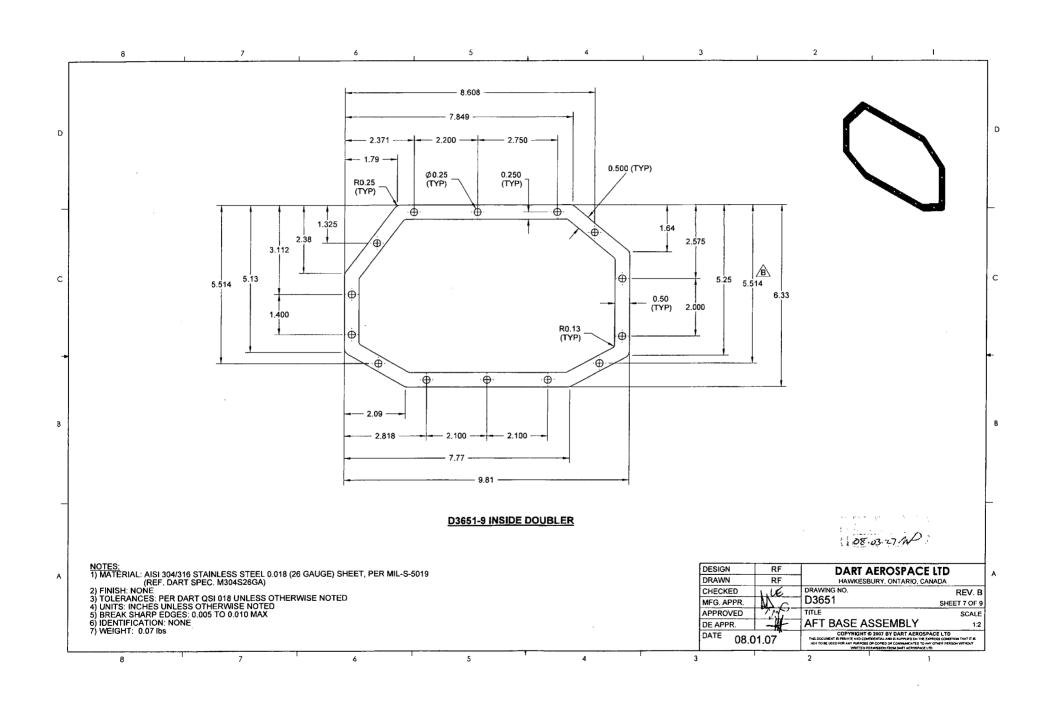


DQA:		Date:													
					WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:	· ·						V	Vork Order up	date only				
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		······································			Rework			Skid-tube	Crosstube	7	Water Jet		Engineering		
Part N	No.				Scrap			Machining	Small Fab	Prod. Eng. Coor.			Quality		
	,				Use-as-is			noforming	Finishing	Rec/Stor		Other			
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,	Cracks				Broken/Damage/Defect		Hardwa	re	L	Part Incorrec	t	_ T	emperature/Cure		
,	Crimp/	Kink/Ripple	e/Wave		Burrs		Inspecti	on Incomplete/Ui	nqualified	Part Lost/Mi	ssing	\^	Veld		
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ļ	Heat Treat				Cut Too Short		Mislabe	led	L	Power Loss/S	Surge	0	ther		
]		ion Strip in	Tube		Drawing		Misread	l							
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	Turning	Sequence			Finish	Out of Calibration									
	Wave/	rwist in Tul	эе		Fit/Function		Out of Sequence								

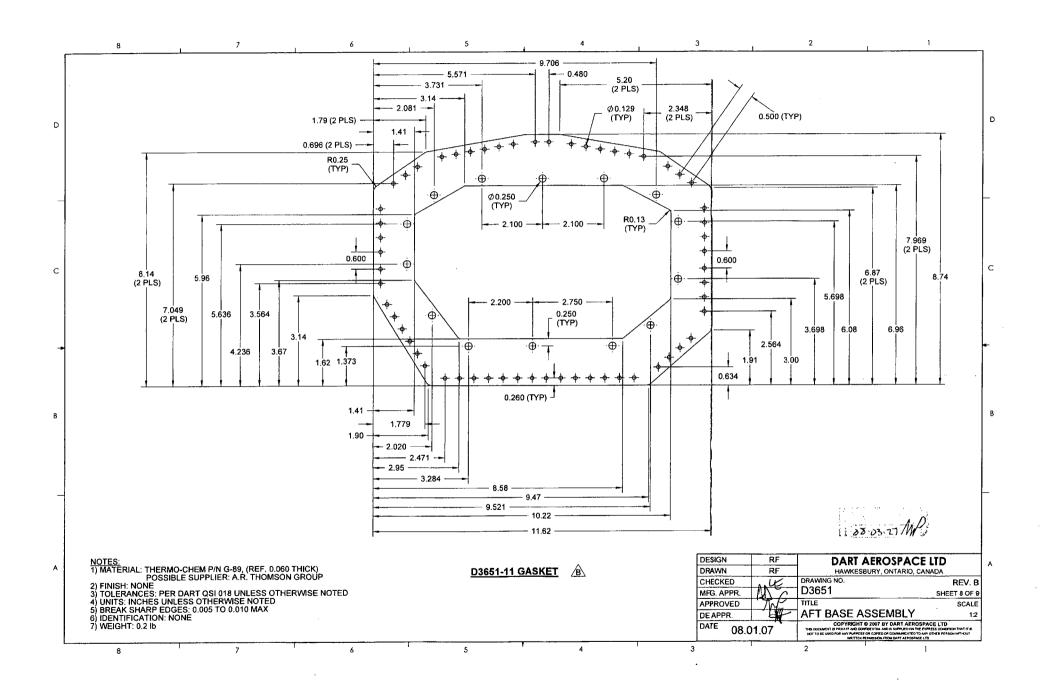
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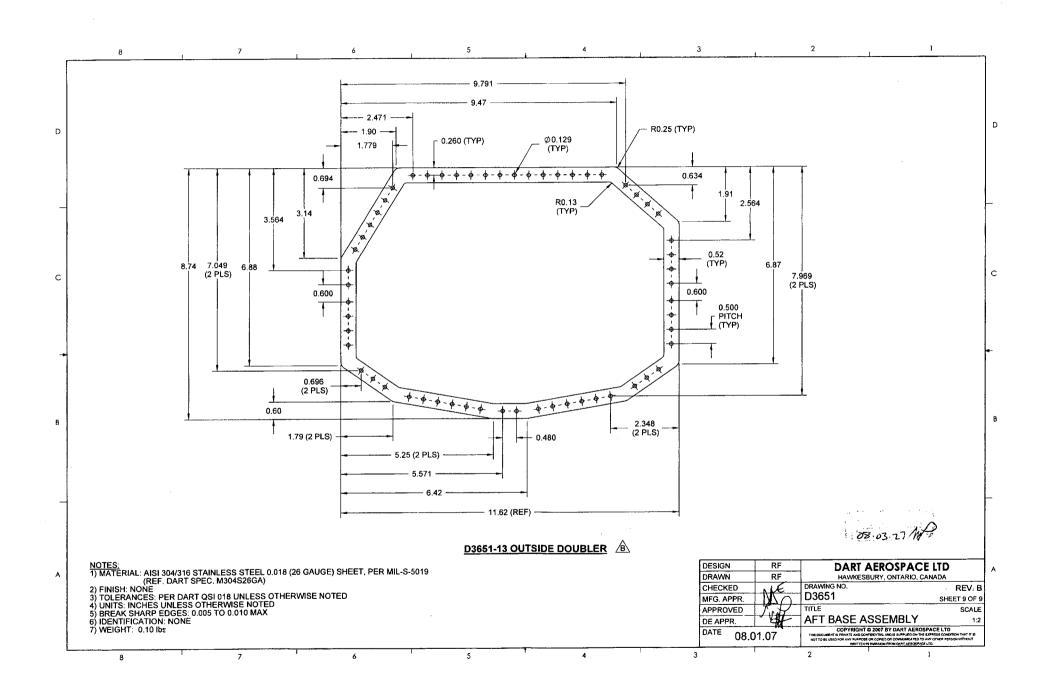
DQA:		_ Date:			- ····································										
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP		/ork Order up	odate only	\neg	AEROSPACE		
•					DISPOSITION					EPARTMENT					
Work Orde	r:				DISPOSITION				AGAINST D						
					Rework			Skid-tube	Crosstube		Water Jet		Engineering		
Part N	0				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality		
					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	\Box	Other		
NCR N	0				Suspected Unapproved		Large Fab	Composite	_	Supplier					
Root				Desci	ription of work order update		Initial	Acti	on	Sign &					
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification		QC Inspector		
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator	_														
Offset/Setup			1												
Process	_														
Supplier	_														
Training	_														
Transport	_														
Unapproved		<u> </u>				<u> </u>									
						FAL	JLT CAT	EGORY							
Landin C					General		l = 1: /s			7					
-	Bending				Bend BOA4 (Barata	\vdash	•	rogram	<u> </u>	Outside Dim	 	_	ressure/Forced		
-	Centre No	ot Concer	itric	-	BOM/Route		Grain		-	Over/Under		_	et-up		
-	Cracks	-1. /D:1.	h		Broken/Damage/Defect		Hardwa			Part Incorred	⊢	→	emperature/Cure		
	Crimp/Kink/Ripple/Wave				Burrs			on Incomplete/Und		Part Lost/Mis	ssing		/eld		
}	Current			-	Contamination	_		ions Incomplete/Ur	nciear	Part Moved	<u>.</u>	_J™	rong Stock Pulled		
-	Crushing				Countersink	_		ned/off center	<u> </u>	Positioned W		ヿ゙	Al		
}	Heat Treat				Cut Too Short	-	Mislabe			Power Loss/S	surge	101	ther		
-	Inspection Strip in Tube Marks/Chatter				Drawing Drill Holes	\vdash	Misread								
-				\mathbb{H}			Off-set	'alibratian							
}	Turning S			-	Finish	-		Calibration							
	Wave/Tw	nscin Tub	e		Fit/Function		out of S	equence							



DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NOW		ONTO	MINIAINCE / C	DEDAIL	W	ork Order up	odate only	\Box	AEROSPACE	
Work Orde	or.					DISPOSITION				AGAINS	r DE	PARTMENT	/PROCESS			
WOIR Old	· · · —					Rework	1		Skid-tube Crosstube			Water Jet			Engineering	
Part N	J۵					}—-	Scrap			Machining Small Fab			d. Eng. Coor.	\vdash	Quality	
,						· -	· ⊢ I			Finishing	-	4	re/Packaging	\square	Other	
NCR N	No			<u> </u>	<u> </u>	Suspected Unapproved		Thermoforming Finish Large Fab Compos			-					
Root					Desc	ription of work order update		Initial	A	ction		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	cription		Date	Verificatio	n	QC Inspector	
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Doc/Data																
Equip/Tooling			-													
Handling/Pre																
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Operator																
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Unapproved							<u> </u>									
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Landir 1						General		1				1	. [5 /5 !	
}		ending	. C	. 4		Bend	⊢	1	rogram		-	Outside Dim			Pressure/Forced	
	Centre Not Concentric					BOM/Route Broken/Damage/Defect	<u> </u>	Grain			-	Over/Under Part Incorred	1	-	Set-up	
	Cracks				-	Burrs		Hardwa		Inqualified	-	Part Incorrec	, , , , , , , , , , , , , , , , , , ,	-	Temperature/Cure Weld	
	Crimp/Kink/Ripple/Wave					Contamination	\vdash	1 '	on Incomplete/Uions Incomplete/	•	\vdash	Part Moved	22111B	-		
	Cuffs Crushing				-	Countersink		4	ned/off center			Positioned W	[Irong		Wrong Stock Pulled	
	Heat Treat				-	Cut Too Short		Mislabe			-	Power Loss/S	· ·	\Box	Other	
	Inspection Strip in Tube					Drawing		Misread			Щ.	J. Ower LOSS/S) u 8		Other	
	Marks/Chatter					Drill Holes	_	Off-set	•							
ŀ						Finish	Out of Calibration					—				
	Turning Sequence					Fit/Function	Out of Sequence									



DQA:	-	Date	2:	w	^ Na a la la la la la la la la la la la la										
					WORK ORDER NON-	-C(ONFO	RMANCE / U	PDATE			AEROSPACE			
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Work Orde	er:			,	DISPOSITION				AGAINST I	DEPARTMENT					
					Rework		1	Skid-tube	Crosstube		Water Jet	Engineering			
Part N	10.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
					Use-as-is			noforming	Finishing		re/Packaging	Other			
NCR N	10				Suspected Unapproved	Large Fab Composite									
Root		1		Desc	I ription of work order update		Initial	Act	tion	Sign &	1				
Cause	Da	te Step	Qty		or non-conformance	1	nief Eng		ription	Date	Verification	n QC Inspector			
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						FA	ULT CAT	regory							
Landir F	ng Gear			_	General		1 .				_				
	Bend	_		-	Bend	<u> </u>	4	rogram		Outside Dim		Pressure/Forced			
		e Not Conc	entric	-	BOM/Route	<u> </u>	Grain			Over/Under	⊢	Set-up			
	Crack			-	Broken/Damage/Defect		Hardwa			Part Incorre		Temperature/Cure			
-		/Kink/Ripp	e/Wave		Burrs	<u> </u>	1	on Incomplete/Ur	· -	Part Lost/M	issing	Weld			
	Cuffs				Contamination	ļ	4	ions Incomplete/L	Jnclear	Part Moved	L	Wrong Stock Pulled			
-	Crush	-		-	Countersink		i -	ned/off center	-	Positioned V					
-	Heat		- '		Cut Too Short		Mislabe		L	Power Loss/	Surge	Other			
•		ction Strip i	n Tube	-	Drawing		Misread	1							
	_	s/Chatter			Drill Holes		Off-set	5 III							
		ng Sequenc		-	Finish	Out of Calibration									
_	Wave	/Twist in Tu	ıbe		Fit/Function	1	Out of S	Sequence							



DQA:		Date:													
					WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:							Wo	rk Order up	date only				
Work Order	·:				DISPOSITION			AGAINST	DEP	ARTMENT	/PROCESS				
					Rework			Skid-tube Crosstube		Water Jet Eng			Engineering		
Part No) .				Scrap			Machining Small Fab	-	Prod. Eng. Coor.			Quality		
					Use-as-is		Ther	moforming Finishing	П	Rec/Store/Packaging			Other		
NCR No	D			_	Suspected Unapproved	Large Fab Composite			Supplier						
Root				Descr	ription of work order update		Initial	Action		Sign &					
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification		QC Inspector		
Design															
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				·		FAI	ULT CA	TEGORY					•		
Landing	Gear				General		_	_							
_	Bending				Bend	_	Folio/F	Program		Dutside Dim	ensions	Pı	ressure/Forced		
	Centre No	ot Concer	ntric		BOM/Route		Grain		∐ ⁽	Over/Under	tolerance	_ S	et-up		
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorrec	t L	T6	emperature/Cure		
<u> </u>	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing .	\w	/eld		
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		w	rong Stock Pulled		
Ĺ	Crushing				Countersink		Misalig	gned/off center		Positioned W	/rong				
	Heat Trea	t			Cut Too Short		Mislabe	eled	ال	ower Loss/S	Surge	0	ther		
	Inspection	n Strip in	Tube		Drawing		Misread	d	_						
	Marks/Ch	atter			Drill Holes		Off-set		_						
	Turning So	equence			Finish	Out of Calibration									
	Wave/Tw	ist in Tub	e		Fit/Function		Out of Sequence								

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